_	Thursday, 11/9/2006 4:34:16 PM Kim Johnston	•		Par de	250	173 E	}
) USEI.	Niii Johnston	Proce	ss Sheet	•	97		
Customer Job Number Estimate Numb P.O. Number This Issue Prsht Rev. First Issue Previous Run Written By Checked & App Comment Additional Proc	: NIA : 11/9/2006 S.O. No. : NO : NC : NC : 11/14 Type : MAC : 24956 : 24956 : Est Rev: C Removed		Part Number Project Number Project Number Drawing Revision Material Due Date	: DOOR HANDLE KIT : D412698013 : N/A : N/A : N/A : N/A : 12/5/2006	Qty:	,8 U m :	Each
Job Number:							
Seq. #:	Machine Or Operation:		Description :				
1.0 Cor	DC	DOCUME	NT CONTROL				8
	Photocopy bluefile and create		98-013CHG001	K-	36	11/13	
2.0	29382A	HANDLE					
3.0	nment: Sub-Component HANDLE 4 x D3203-1 B 29382B		29382A S	ρχ			
		:					· .
4.0	mment: Sub-Component DOUBLER A x D3220-041 B 2 495 293820	6 C 5 X	24956 B	3×		<u></u>	
9		<u>Q</u>	in it				
5.0	1 x D3220-042 B 29 382D	DOUBLER	1/4/12/18				
	nmonts C. I. Commonts DOUBLED	13293220	.7X				
6.0	nment: Sub-Component DOUBLER 2x D3220-3 B 24956 PACKAGING 1		// 4/12/18 NG RESOURCE#1				
Con	nment: PACKAGING RESOURCE #1 Pick Packing Kit 4 items above plus hardware						

W/O:		WORK ORDER CHANG	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
							:					
				<u> </u>								
Part No	o:	PAR #: Fault Category:	_ NCR: Yes	No DQ	A: 2		56/12/19					
			QA:	N/C Close	d:	Date: _						

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	 	Verification	Annroval	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	

Date: Thursday, 11/9/2006 4:34:17 PM 📑 Kim Johnston User: **Process Sheet** Drawing Name: DOOR HANDLE KIT Customer: CU-DAR001 Dart Helicopters Services Job Number: 29382 Part Number: D412698013 Job Number: Description: Seq. #: Machine Or Operation: AN960JD416L Washer 7.0 8.0000 Each(s)/Unit Total: 64.0000 Each(s) Comment: Qty.: Pick: Packing Kit Qty Part Number Description Batch ν 8 AN960JD416L Washer Μ1.1237 -Nut MS21042L4 8.0 8.0000 Each(s)/Unit Total: 64.0000 Each(s) Comment: Qty.: Pick: Packing Kit ✓8 MS21042L4 MS24694S98 9.0 Comment: Qty.: 16.0000 Each(s)/Unit Total: 128.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch Screw M/6255 7X M/02728 /21 X 16 MS24694-S98 QC4 10.0 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING 1 PACKAGING RESOURCE #1 11.0 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-698-013 Location: FINAL INSPECTION/W/O RELEASE QC21 12.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion (Loce 12119

W/O:		WORK ORDER CH	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				- تر,			
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQA	۱:	Date: _	

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORI	DER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		
		*						
 								
				1				
							1	

Thursday, 11/9/2006 4:34:19 PM Date: Üser: . Kim Johnston **Process Sheet** 100 **Drawing Name** : HANDLE : CU-DAR001 Dart Helicopters Services Customer Job Number : 29382A : 10293 **Estimate Number** : MA : D32031 **Part Number** P.O. Number S.O. No. : N/A : D3203 REV C : 11/9/2006 **Drawing Number** This Issue : N/A **Project Number** Prsht Rev. : NM : MACHINED PARTS **Drawing Revision** Type First Issue : NIA : 24956A Material **Previous Run** 32 Um: Each : 12/5/2006 Qty: **Due Date** Written By Checked & Approved By Comment : Est Rev:A 05-11-06 JLM **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: **PURCHASING** 1.0 PG Comment: PURCHASING capel ullo 18sue P/O: 2468 Possible Supplier: Mill Supply P/N GH-180-C order (4) per Kitldentify for D3203-1 Conformity certificate is required Handle 2.0 GH180C Total: 32.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Handle PACKAGING 1 PACKAGING RESOURCE #1 3.0 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of confomity is attached QC6 4.0 Comment: DIMENSIONAL CHECK PACKAGING RESOURCE #1 5.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No		PAR #: Fault Category: N	NCR: Yes	No DQA		_ Date: <u> </u>	86/11/16		

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Ammanal	Approval QC Inspector				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng					
ı								:				

Date:

Thursday, 11/9/2006 4:34:19 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE

Job Number: 29382A

Part Number: D32031

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Par #: Pault Category: NC	R: Yes	s No DQA	۸:	Date:	

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E	3	Verification	Annessal	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng				
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	DESIGN	A DI	RAWN BY		OSPACE LTD ONTARIO, CANADA
1	CHECKE	D AF	PROVED	DRAWING NO.	REV. C
		W	4	D3203	SHEET 1 OF 1
ŀ	DATE			TITLE	SCALE
	04.11	.26		HANDLE	1:2
	Α	(03.08.27	NEW ISSUE	
	В		03.10.16	REDESIGN HANDLE	
Γ	С	į	04.11.26	NO MACHINING	

RELEASED

	7.00 	Ø0.318 (REF) (TYP 4 PLACES)
1.00		
1.71 (REF)		
:	 E	0.26 (REF)
	SYMMETRIC	

D3203-1 HANDLE

1) PURCHASE FROM MILL SUPPLY, P/N GH-180-C OR 27-526

2) FINISH: NONE
3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

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MILL SUPPLY, INC.

19801 MILES ROAD, CLEVELAND, OHÍO 44128-4117 REMIT TO: P.O. BOX 28750, CLEVELAND, OHIO 44128-0750



512306

INVOICE

TO:

11/10/2006

INVOICE

INVOICE & SHIP DATE CREDIT CARD

TOM FRENCH 09/09 039505 N

SHIP #

PHONE

CUSTOMER #

PHONE

DARTK6A1K S-48 613-632-9577

DECTO DV

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY ON K6A1K7

SHIP TO:

ENTER DATE		P.O. NUMBER	SALESMAN	TERMS	OTHER INFO
11/10/2006	ORDERED BY	20002468	DAVE NET		•
QTY U/M	PART NUMBER	DESCRI	PTION	PRICE	EXTENSION
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1/1/18		{****************			
		* Our 176-päge stepv	yan p∯∕ts. *		
(*) (*)		+ catalog is availat + charge – call 1-80	10-888-5072 *		
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*** PLEHOE		7. LU(U4. White Finance			
SHIPPED VIA	PKGS THANK YO	U FOR YOUR ORDER	PLEASE NOTE	MERCHANDISE	223.36
ED PRIORITY 1	Inspect all p	ackages for damage or	PLEASE PAY BY THIS INVOL	CE TAX	0.00
WGHT. CHGS. WGT	miss	antantad within 7 days if	ACCORDING TO THE TERMABOVE. Past due invoic	es Selie Tarni	223.36
	there is a pr	oblem with your order.	subject to 1-1/2% per mor service charge.	SHIPPING &	0.00 (
		CK FOR DETAILS e goods were produced, or services performed	S20 FEE FOR RETURNED CHECKS	HANDLING	
	in compliance with all applic	able requirements of Section 6, 7 and 12 of the	RETURN POLICY ON BACK		223.36
\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	the United States Department	ent of Labor issued under Section 14 hereof.			

Thursday, 16/11/2006 9:47:47 AM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 29382B

Estimate Number

: 10294

P.O. Number This Issue

: NIA

: 16/11/2006

A14: .01.0.2

Prsht Rev. First Issue

Previous Run

: NC : 09/11/2006

: 26044

Written By

Checked & Approved By

Comment

: Est Rev:A New Issue

Type

: MACHINED PARTS

Part Number. **Drawing Number**

Drawing Name

Project Number

. D3220 REV A1 : N/A

: D3220041

Drawing Revision MU: Material

Due Date

: 05/12/2006

: DOUBLER ASSEMBLY

Qty:

Each 8 Um:

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M2024T3S050 1.0

2024-T3 .050 sheet

Comment: Qty.:

0.7266 sf(s)/Unit Total:

5.8128 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

(M2024T3S.050 Identify for D3220-1 Batch: <u>MI905</u> 3

2.0

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut D3220-1 as per Dwg D3220

Dwg Rev:__/ Prog Rev:_

2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE

3.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

ociliza D

Comment: SECOND CHECK

5.0

SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 06:11:27

Ву	Date	04	Approval	
		Qty	Chief Eng / Prod Mgr	Approval QC Inspector
:				
		-		
:				
_				

Part No:	_ PAR #:	Fault Category:	NCR: Yes N	DQA:	Date:
·			QA: N/C	Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Approval	Approve	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
•								
,								

Thursday, 16/11/2006 9:47:47 AM Date: Linda Lacelle User: **Process Sheet** Drawing Name: DOUBLER ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 29382B Part Number: D3220041 Job Number: Description: Seq. #: **Machine Or Operation:** 16:111:27 2-C'sink D3220-1 as per Dwg D3220 INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 7.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 X8 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 9.0 MS20426AD34 Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s) Pick: Description Batch **Qty Part Number** M 15786 8 MS20426AD3-4 Rivet 10.0 MS21059L4 Nutplate Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s) Pick: Description Batch_ **Qty Part Number** Nutplate 1919522 120 4 MS21059L4 M102959 X12 SMALL & MEDIUM FAB RESOURCE 1 11.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB.RESOURCE 1 Assemble D3220-041 doubler as per Dwg D3220 INSPECT WORK TO CURRENT STEP 12.0 QC5 Comment: INSPECT WORK TO CURRENT STEP

W/O:							
DATE	STEP	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
					-		
							:
Part No:		PAR #: Fault Category:	NCR: Yes	No) DQ		│ ◯ Date: ౖ	

QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	A	
DATE	STEP	Section A	Initial Action Description Sign & Date		Section C	Approval Chief Eng	Approval QC Inspector	
						'		

Date:

Thursday, 16/11/2006 9:47:47 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 29382B

Part Number: D3220041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



14.0



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CLocel 12/18

Dart Ae	rospace	Liu							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE By			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	_ Date: _	
					QA: N	/C Close	d:	_ Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	2)			
		Description of NC		Corrective Action Section	ion B	Verification		Annessal	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Approval Chief Eng	Approval QC Inspector
1									

DART AEROSPACE LTD	Work Order:	29382B
Description: Doubler	Part Number:	D3220-1
Inspection Dwg: D3220 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

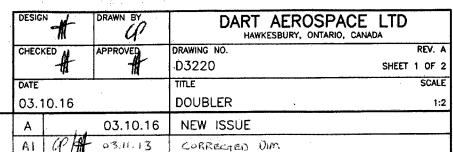
)	First Arti	cle	Prot	otype
Drawing	Tolerance	Actual	Accept	Reject	Method
Dimonsion	Tolerance	Dimension	Accept	Reject	Inspectio

Drawing	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dimension 5.50	+/-0.030	+				
		5.514			Vern	
14.25	+/-0.030	14.26			Vern	
R0.50	+/-0.030	R0,50			Vern	
7.00	+/-0.030	7.01			Vorn	
7.000	+/-0.005	7,004			vern	
1.50	+/-0.030	1.50			Vern	
1.000	+/-0.005	1.000			Vern	
0.500	+/-0.005	0.500	./		Vern	
1.000	+/-0.005	0.997			Very	
0.316	+0.005/-0.000	A-2031A			Vern	
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0.050 thick	+/-0.005	0.049	1		Vern	
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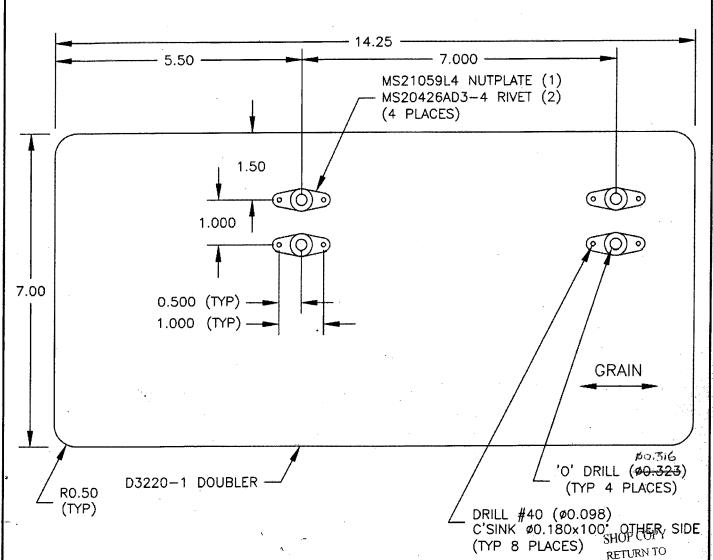
		1 .A		
Measured by:	TAN	Audited by:	Prototype Approval:	N/A
Date:	06: NF 25	Date: 00/11/27	Date:	N/A

Rev	Date	Change		Revised by Approv∉d
Α	04.02.27	New Issue	P/O D412-698-013	KJ/RF OK
·				









D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER) NGINEERING

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK

(REF DART SPEC. M2024T3S.090)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

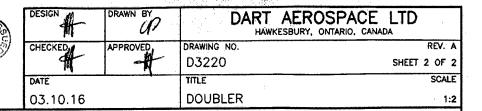
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WITHOUT NOTICE

WORK ORDER

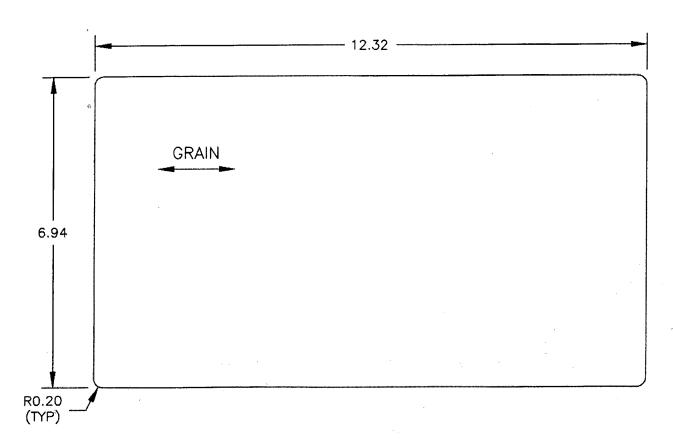
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D3220-3 DOUBLER

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK (REF DART SPEC. M2024T3S.050)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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Qty:

8 Um:

Each

: DOUBLER ASSEMBLY

: D3220042

: 05/12/2006

: N/A

: D3220 REV A1

✓ Date:

Thursday, 16/11/2006 9:49:30 AM

User:

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Type

Job Number : 29382C

Estimate Number P.O. Number

: 10295

This Issue

: NA

: 16/11/2006

S.O. No. : NIA

: NC Prsht Rev.

First Issue **Previous Run** : 09/11/2006

: 25552

Written By

Checked & Approved By

Comment

: MACHINED PARTS

: Est Rev:A New Issue

Additional Product

Job Number:



Seq. #:

Description:

2024-T3 .050 sheet

1.0 M2024T3S050

Comment: Qty.:

0.7266 sf(s)/Unit Total: 5.8128 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.050" thick

(M2024T3S.050 Identify for D3220-2 Batch: M19053

2.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut D3220-1 as per Dwg D3220

Dwg Rev: 4 Prog Rev: AL

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK





Comment: SECOND CHECK

SMALL FAB 1 5.0

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

Page 1

W/Ó:	,		WORK ORDER CHANGES						
DATE	STEP			PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
**************************************			2 -						
			······································						
		:							

Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annuoval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, 16/11/2006 9:49:30 AM Date: Linda Lacelle User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: DOUBLER ASSEMBLY Job Number: 29382C Part Number: D3220042 Job Number: Description: Seq. #: **Machine Or Operation:** 2-C'sink D3220-2 as per Dwg D3220 QC5 INSPECT WORK TO CURRENT STEP 6.0 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 HAND FINISHING 7.0 Comment: HAND FINISHING RESOURCE #1 XF Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION RIVET MS20426AD34 9.0 Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s) Pick: Description Batch **Qty Part Number** x64 MS20426AD3-4 Rivet 10.0 MS21059L4 Nutplate Comment: Qty.: Total: 32.0000 Each(s) 4.0000 Each(s)/Unit Pick: X32 Description Batch_ **Qty Part Number** MS21059L4 SMALL & MEDIUM FAB RESOURCE 1 11.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble D3220-042 doubler as per Dwg D3220 INSPECT WORK TO CURRENT STEP QC5 12.0 **Comment: INSPECT WORK TO CURRENT STEP**

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				 			
Part No	:	PAR #: Fault Category: N	NCR: Yes	No DQA		<u>)</u> Date: <u>(</u>	8d12/19
			QA:	N/C Closed	i:	Date: _	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	A1	Approval QC Inspector	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng		

Thursday, 16/11/2006 9:49:30 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 29382C

Part Number: D3220042

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

PACKAGING 1

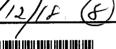
PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FINAL INSPECTION/W/O RELEASE



14.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

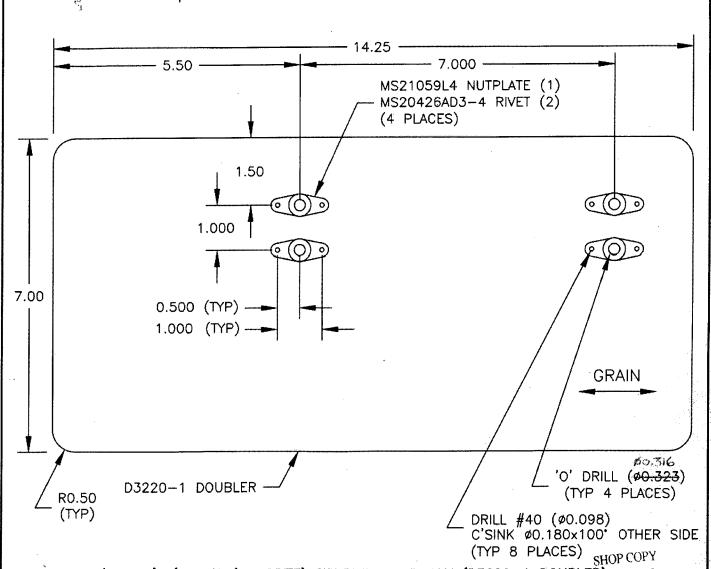


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W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			-						
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	_ Date: _	
					QA: N	I/C Close	d:	Date:	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	₹)			
DATE	STEP	Description of NC	Description of NC Section A Corrective Action Section			Verific	fication Approva	Approval	Approval
	SILI	Section A			Sign & Date	Section C		Chief Eng	QC Inspector
ž.									



DESIG	* #	DRAWN BY	DART AEROSP, HAWKESBURY, ONTARIO	
CHECK	KED A	APPROVED	DRAWING NO.	REV. A
	#	#	.D3220	SHEET 1 OF 2
DATE		<u> </u>	TITLE	SCALE
03.1	0.16	•	DOUBLER	1:2
Α		03.10.16	NEW ISSUE	
A 1	10 4	1. 12 ii 1. 7	1 1 2 3 m = 1 1 1 m	

RELEASED



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER) TURN TO

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK (REF DART SPEC. M2024T3S.090)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT NOTICE

WORK ORDER

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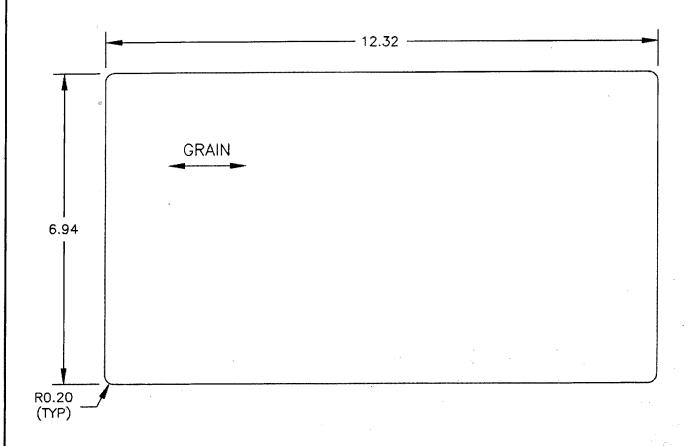
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DESIGN	DRAWN BY		ROSPACE LTD Y, ONTARIO, CANADA
CHECKED	APPROVED,	DRAWING NO.	REV. A
#	1	D3220	SHEET 2 OF 2
DATE		TITLE	SCALE
03.10.16		DOUBLER	1:2





D3220-3 DOUBLER

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
- (REF DART SPEC. M2024T3S.050) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER

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DART AEROSPACE LTD		Work Order:	293820
Description:	* 3 4 4	Part Number:	
Inspection Dwg:	v:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article X Prototype

						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.50.	7-0,030	5.504			Vern	
14,25	1/- 0.030	14.26	/		Vern	
R0,50	1/ 0.030	RO.50	/		R-6	
7,00	20,030	7.005	/		Vern	
7.000	+/-0.005	7.003	. /		Vern	·
1.50	t/-0.030	1,498	V		Vern	
1.000	1-1-0,005	0.997			Vern	
0,500	1/20,005	0.496			Vern	
1.000	4-0.005	0.996			Vern	
0.316	40.005	0.319			Vern	
6.098	+ 0.005/ - 0.000	0,101			Vern	
0,050	+/2 0,005	0.048	V		Vern	
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		5				

Measured by:	SAO	Audited by:	Prototype Approval:	
Date:	06:01:26	Date: \$16/11/27	Date:	

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	